

Date: Wednesday, 1/18/2006 10:28:07 AM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: K10007
Job Number	: 25543		
Estimate Number	: 10804		
P.O. Number	: N/A	Part Number	: K10007
This Issue	: 1/18/2006 S.O. No. : N/A	Drawing Number	: RTN 440
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: M/A Type : N/A	Drawing Revision	: N/A
Previous Run	: 00015	Material	: N/A
Written By	: <u>SEE ABOVE DATE & USER</u>	Due Date	: 1/25/2006 Qty: 1 Um: Each
Checked & Approved By	: <u>SEE ABOVE DATE & USER</u>		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	QC5	INSPECT WORK TO CURRENT STEP
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206-01-18

Comment: INSPECT RTN 440

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

ADD THE FOLLOWING PARTS TO KIT (USED):

4 X D2182B050 B B23172
 4 X D2438 B B23818
 8 X D2529 B B25372
 8 X AN4-15A B M19085
 8 X AN4-17A B 4x m14526/m15432x4
 2 X QS200M44S B M19504
 PAPERWORK

C 206101/23 ①

3.0	D2182B	Neoprene Cushion-.750 bl
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Comment: Qty.: 0.4166 f(s)/Unit Total : 0.4166 f(s)
 Neoprene Cushion-.750 bl

4.0	D2438	Clamp
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Clamp

5.0	D2529	Washer
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Washer

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN415A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Bolt

7.0

AN417A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Bolt

8.0

QS200M44S

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Clamp

9.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
REPACKAGE PER PPP

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
INSPECT LEVEL 21

54C 06/01/25

①



66/01/24

Job Completion



48
DART AEROSPACE LTD

Work Order:

19896

Description: Bearpaw Kit (19" x 16")

Part Number:

K10007

Dwg: D2435 Rev. E1

Qty:

20

Page 1 of 1

Step	Location	Procedure	By	Date	Qty																																																
1	DC	Issue Traveler Note: (1) K10007 Kit consists of Qty (2) D2435 Dwg not required	HA	03.11.06	20																																																
2	DC	Photocopy bluefile: K10007 D206-559 D500-572 D120-638 D058-678 and create labels per PPP K10007 CHG003 (Bag Bluefiles separately) WK 46 WJ	HA	03.11.13 04.01.15	10 10																																																
3	GA	Cut 2 blanks per K10007 Kit Cut blank: 16.00" x 20.00" x 1.00" thick Material: Black UHMW 1" (MUHMWB10) Batch: 114320 Identify as D2435 44777	R.G. P.D.	04.01.26	10 10																																																
4	MV	Inspect material for defects or damage prior to machining	HA	04.01.29	20																																																
5	MV	Machine as per Folio D2435 and Dwg D2435	HA	04.01.29	20																																																
6	QC2	Inspect parts as they come of the CNC machine	HA	04.01.29	20																																																
7	MV	Deburr	HA	04.01.29	20																																																
8	QC8 & 5	Second inspection	EL	04.02.01	20																																																
9	KP	Pick: Packing Kit (Note: D2435 is not on the BOM, but is in as material from step 3) <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>4</td><td>D2182B050</td><td>Rubber Cushion</td><td>B19540</td></tr><tr><td>8</td><td>D2274</td><td>Radius Block</td><td>B19599 B19922</td></tr><tr><td>2</td><td>D2435</td><td>Bearpaw</td><td>B19896</td></tr><tr><td>4</td><td>D2438</td><td>Clamp</td><td>B20089A B19615</td></tr><tr><td>8</td><td>D2529</td><td>Washer</td><td>B20090 B18930 B19486</td></tr><tr><td>8</td><td>AN4-15A</td><td>Bolt</td><td>M13437</td></tr><tr><td>8</td><td>AN4-17A</td><td>Bolt</td><td>M12692</td></tr><tr><td>16</td><td>AN960JD416</td><td>Washer</td><td>M13719</td></tr><tr><td>8</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M13276 M13928</td></tr><tr><td>2</td><td>QS200M44S</td><td>Clamp</td><td>M14019 M13928 M14312</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2;</td></tr></table>	Qty	Part Number	Description	Batch	4	D2182B050	Rubber Cushion	B19540	8	D2274	Radius Block	B19599 B19922	2	D2435	Bearpaw	B19896	4	D2438	Clamp	B20089A B19615	8	D2529	Washer	B20090 B18930 B19486	8	AN4-15A	Bolt	M13437	8	AN4-17A	Bolt	M12692	16	AN960JD416	Washer	M13719	8	MS21042L4	Nut (or -4)	M13276 M13928	2	QS200M44S	Clamp	M14019 M13928 M14312	1	Paperwork package from Step 2;			HA	04.11.16	20
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1	Paperwork package from Step 2;																																																				
10	QC4	Inspect Kit for 100% Completeness on the W/O	HA	04-02-02	20																																																
11	PK	Identify and pack for shipping as per PPP K10007	HA	04-02-02	20																																																
12	AC	Cost / part 162.20	545	04-02-03	20																																																
13	DC	Close W/O 156.57 Inspect Level 21	HA	04.02.03	20																																																

Rev	Date	Change	Revised By	Approved
A	99.12.17	K10007 created for Bear paw kit (MPP 2000)	EC	
B	01.03.21	Added OH-58 paperwork (MPP 2092)	EC	
C	01.11.08	Revised Step 3 and Added Level 21	SM	
D	03.03.26	Reformat; Incorporated D2435	KJ/RF	